

Work Order ID 65324

January 11, 2011 2:24:42 PM



Page 1

Item ID: D2807-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Door prop

Start Date: 1/11/11 Start Qty: 20.00



Cust Item ID:

Required Date: 1/17/11 Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals: Process Plan: CL Date: 11/01/11 Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2807	Rev E

100 PURCHASING 0.00



Purchasing

Memo

0.00

Purchasing

Issue P/O: 13258 ☐ Order as per Dwg D2807 ☐ Possible
supplier: Lift Support Technologies, Saskatoon, Canada ☐ P/N 6/15-164/50-115N
☐
Material release note is required

CL 11/01/11 (20)

110 Receive & Inspect for Damage & Mat'l Certs 0.00



Packaging

Memo

0.00

Packaging

Ensure Material Release Note is attached

11/01/18 (20)

120 QC6- Inspect dimensions to drawing 0.00



QC

Memo

0.00

Quality Control

511/01/21

100/01/18 (20)

test at 35 lbs.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 65324



Page 2

January 11, 2011 2:24:42 PM

Item ID: D2807-041

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Small Fab	0.00				(20X)			
Small Fab	Memo	0.00							
Small Fab	1-install D3671-1 as per dwg D2807								
140 	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00				(x20)			
Quality Control									
150 	Identify as per dwg & Stock Location: 22	0.00							
Packaging	Memo	0.00							
Packaging									

7M-1 11/01/24

Sublot 24

cont
(x20)

11/1/24 (20X) SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

January 11, 2011 2:24:42 PM

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Setup Start

Abstract

Stop

Cust Item ID:

Start Date: 1/11/11 **Start Qty:** 20.00



Customer:

Required Date: 1/17/11 **Req'd Qty:** 20.00

Reference:

Run Start

[illegible]

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop

[illegible]

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Operation Description

Set Up/ Run Hours

Tool ID

Tool #**Plan
Code**

Accept Qty

Reject
QtyReject
Number

**Insp.
Stamp**

160

QC21- Final Inspection - Work Order Release

0.00

[illegible]

QC

Memo

0.00

Quality Control

OK 11/01/25

MF

11-01-24

Picklist Print

Page 1

January 11, 2011 2:24:41 PM

Work Order ID: 65324

Parent Item: D2807-041

Parent Item Name: Door prop



Start Date: 1/11/11

Required Date: 1/17/11

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP: D 07.11.12 ecn1019, replaces D2807 EC verified by DD
IPP Rev:E 08-02-12 ECN 1111 DD verified by: ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
6/15-164/50-115N 		Purchased	No			130	Each	0.0000	1	20			
Gas Spring D3671-1 		Manufactured	No			110	Each	19.0000	1	20			
Placard													

Location

Loc Qty

Loc Code

ST074

19

61892

19

19

65324 (signature)
11/1/11 (signature)
65325 (signature)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

SPECIFICATION CONTROL DRAWING

CL 4/10/11
W10:65324

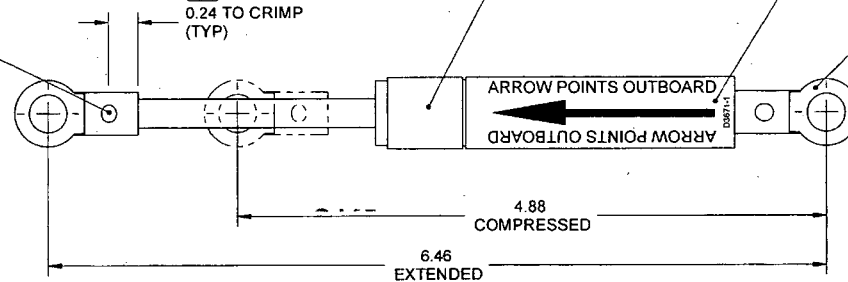
(ALTERNATE ONLY)
CRIMP 0.015-0.025 DEEP
WITH Ø0.375 TOOL AT
2000psi (REF), TYP TWO
SIDES PER LUG

0.24 TO CRIMP
(TYP)

D2807-5
OR
(ALTERNATE ONLY) D2807-1

AFFIX D3671-1 PLACARD
ENSURE PLACARD DOES NOT
CONCEAL ANY TEXT OR MARKINGS
ON THE GAS SPRING

(ALTERNATE ONLY) D2807-3
BOTH ENDS



D2807-041 GAS SPRING

RELEASED
05-12-11

D2807-041 GAS SPRING ASSEMBLY PARTS LIST

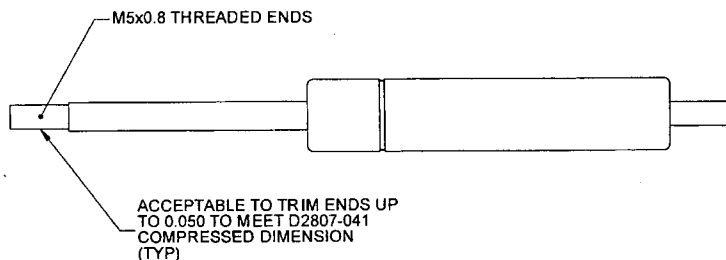
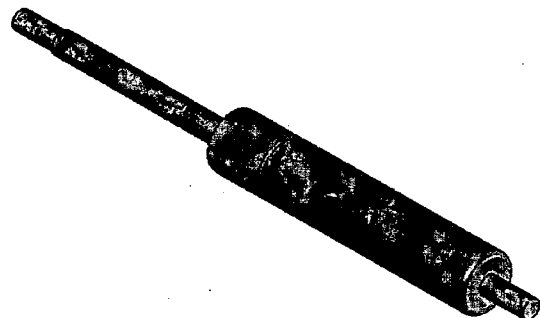
QTY -041	PART NUMBER	DESCRIPTION
X	D2807-041	GAS SPRING ASSEMBLY
1	D2807-5	GAS SPRING
1	D3671-1	PLACARD

NOTES:

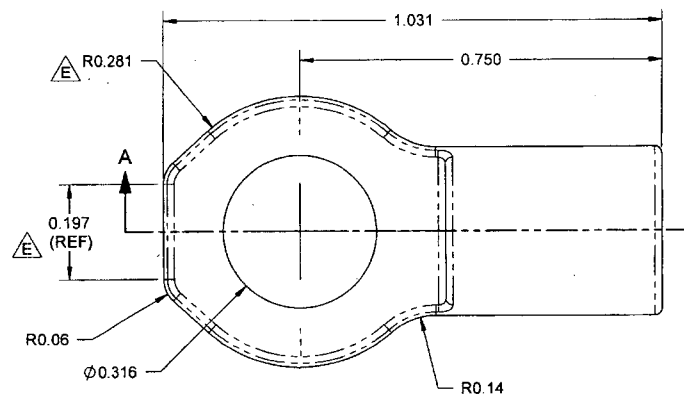
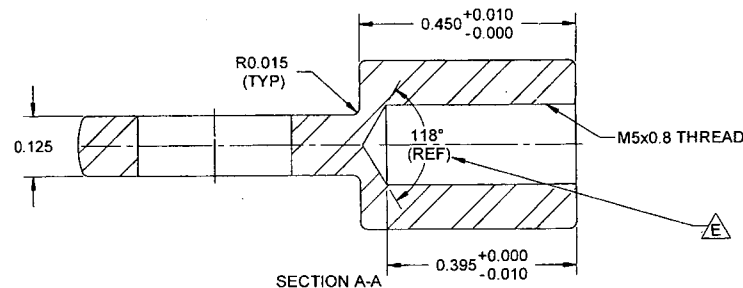
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.169 LBS
- 8) ALTERNATE PART: D2807-5 CAN BE MADE FROM ASSEMBLING D2807-1 (1) AND D2807-3 (2)
(WEIGHT: 0.176 LBS)

E	ADD D2807-5 GAS SPRING; D2807-1/-3 ASSEMBLY IS AN ALTERNATE TO D2807-5 GAS SPRING; UPDATE DIMENSIONS ON D2807-3	PH	07.12.28
D	ADDED D3671-1 PLACARD ADDED -041 ASSEMBLY UPDATED DWG	DC	07.09.27
C	CHANGE SPRING TO SS, ADD -3 LUG	CP	05.05.25
B	ADD FINISH	CP	05.03.16
A	NEW ISSUE	DS	00.11.03
REV.	DESCRIPTION	BY	DATE
DESIGN	4	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	4		
CHECKED	4	DRAWING NO.	REV. E
MFG. APPR.	4	D2807	SHEET 1 OF 3
APPROVED	4	TITLE	SCALE
DE APPR.	4	GAS SPRING	NTS
DATE	07.12.28	<small>COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

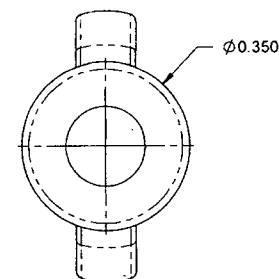
8 7 6 5 4 3 2 1



D2807-1 GAS SPRING
SCALE 1:1



D2807-3 LUG



W10:65324

RELEASED

D2807-1 GAS SPRING NOTES:

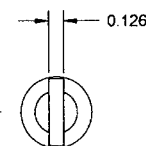
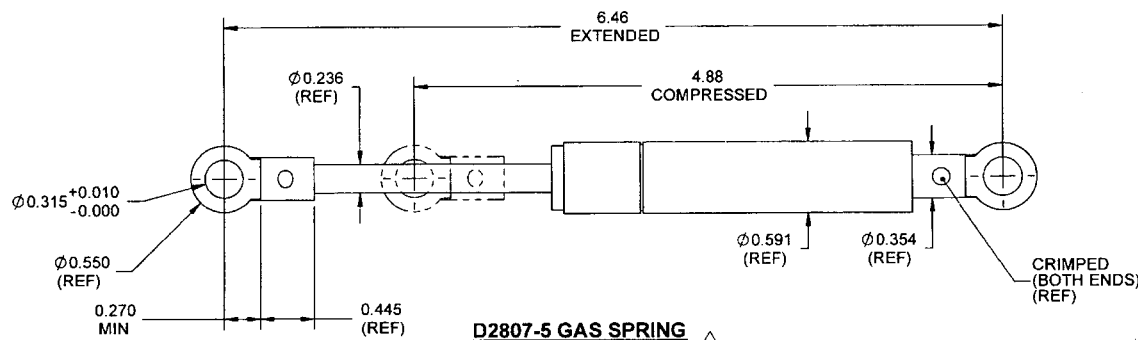
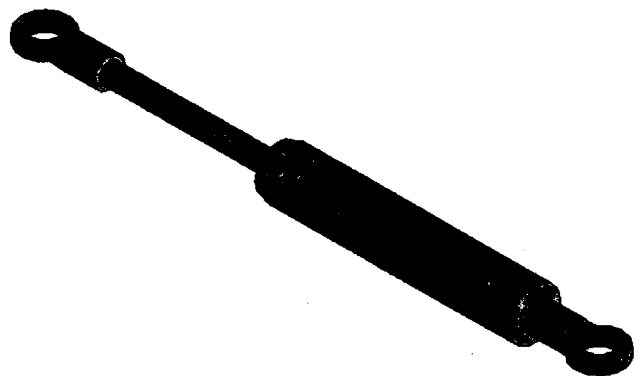
- 1) POSSIBLE SUPPLIER: ARVINMERITOR MOTION CONTROL SYSTEMS, LEICESTER, UK
(P/N SXF6S6050080S6L-115N)
(REF: 80MM LONG CYLINDER, 50MM STROKE, 115N LOAD)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.144 LBS
- 8) SPECIFICATION: SS GAS SPRING
ACCEPTABLE LOAD RANGE IS 25 LB (115 N) MIN TO 45 LB (200 N) MAX
M5x0.8 THREADS

D2807-3 LUG NOTES:

- 1) MATERIAL: AISI 303 ROUND BAR (REF. DART SPEC. M303R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.015
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.016 LBS

DESIGN	W10	DART AEROSPACE LTD	
DRAWN	W10	HAWKESBURY, ONTARIO, CANADA	
CHECKED	W10	DRAWING NO. D2807	REV. E
MFG. APPR.	W10	SHEET 2 OF 3	
APPROVED	W10	TITLE GAS SPRING	SCALE 4:1
DE APPR.	W10	COPYRIGHT © 2000 BY DART AEROSPACE LTD	
DATE	07.12.28	THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1



D2807-5 GAS SPRING

W10.65324

RELEASED
08-02-12

D2807-5 GAS SPRING NOTES:

- 1) POSSIBLE SUPPLIER: LIFT SUPPORT TECHNOLOGIES, SASKATOON, CANADA (P/N 6/15-164/50-115N)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.169 LBS
- 8) SPECIFICATION: SS GAS SPRING WITH END FITTINGS, ACCEPTABLE LOAD RANGE 25 LB (115 N) MIN TO 45 LB (200 N) MAX

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	PH		
CHECKED	HE	DRAWING NO. D2807	REV. E
MFG. APPR.	HE	SHEET 3 OF 3	
APPROVED	HE	TITLE GAS SPRING	SCALE 4:1
DE APPR.	HE	COPYRIGHT © 2000 BY DART AEROSPACE LTD	
DATE	07.12.28	THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR TRANSMITTED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO13258**

Purchase Order Date 1/11/11

PO Print Date 1/11/11

Page Number 1 of 1

Order From :

VC-LST0001

LS TECHNOLOGIES INC.
303-103 STREET
SASKATOON, SK S7N 1Y9
CA

Contact Name

Vendor Phone

306 683 5000

Vendor Fax

306 683 6403

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

10127-2607

Tax Resale Nbr

Net 30

Terms

Currency

CAD

FOB

Destination-Collect

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FAXED
1/11/11

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	6/15-164/50-115N	Gas Spring	1/17/11 Yes	20.00 Each	FedEx PI collect	\$63.9000	\$1,278.00

Special Inst: AS PER DWG D2807 REV. E
B65324
LS TECHNOLOGIES P/N: 6/15-164/50-
115N

PO Total:

\$1,278.00

CERTIFICATE OF CONFORMITY
REQ'D UPON DELIVERY

Change Nbr: 1

Change Date: 1/11/11

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

LS Technologies Canada Inc.

303 - 103 Street
Saskatoon, SK Canada
S7N 1Y9

Packing Slip

Date	Invoice #
1/11/2011	6827

Name / Address
Dart Aerospace Ltd 1270 Aberdeen St. Hawkesbury, ON K6A 1K7

Ship To
Main Finished Goods Location Dart Aerospace Ltd 1270 Aberdeen St. Hawkesbury, ON K6A 1K7

P.O. No.	Ship	Via	FOB	Project
13258	1/11/2011	Fed-Ex		

Qty	Description
20	D2807 Stainless Gas Spring (6/15-164/50-115N) Shipping Via FED EX Tracking # 576900015000171



303 - 103rd Street, Saskatoon, Saskatchewan, Canada S7N 1Y9
Ph: (306) 683-5000 Fax: (306) 683-6403
E-mail: lstech@lstechtechnologies.ca www.liftsupporttechnologies.com

Certificate of Compliance

January 11, 2011

This is to certify that the parts listed below meets specifications as required by your order.

20 Units: D2807 Stainless Gas Spring (6/15-164/50-115N)

Country of Manufacture : Canada

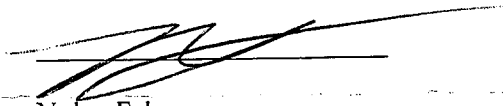
Date of Manufacture : Jan 2011

This product is ROHS compliant.

Purchase Order # 13258

Sullivan

L S Technologies Inc Canada



Nolan Fehr
President